

Date: Wednesday, 3/14/2007 12:25:50 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 31199	
Estimate Number : 12467	
P.O. Number : N/A	Part Number : D35121
This Issue : 3/14/2007 S.O. No. : N/A	Drawing Number : D3512 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28971	Material : N/A
Written By : <u>07.03.14</u>	Due Date : 3/30/2007 Qty: 12 Um: Each
Checked & Approved By : <u>07.03.14</u>	
Comment : Est Rev: A New Issue 06-06-20 JLM	
Est Rev: B Now SS as per Rev B 06-12-15 JLM	

## Additional Product

Job Number:



Seq. # :	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.2741 sf(s)/Unit Total : 3.2886 sf(s)  
 304 SS .063" THK (16 GA)  
 (M304S16GA)  
 Batch: M101873 SAD 07/03/17 (12)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3512  
 Dwg Rev: B  
 Prog Rev: B

2-Deburr if necessary SAD 07/03/05 SAD 07/03/12 (12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/03/17 (12)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK 07/03/19 (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary SAD 07/03/24 12  
 Form as per dwg D3512 using DT8179 DC 8326 end DT 8261 SB 07/03/28 (12)

E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31199

Part Number: D35121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-28 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

Qty Description Batch

A/R 7560 Hardcoat Rod

M102755

FC 07-03-29 (12)

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07/03/29 (12)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

HJ 07-03-29 (12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-H

(12x) 07/03/29

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP

EP

07/03/29 (12)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



U 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

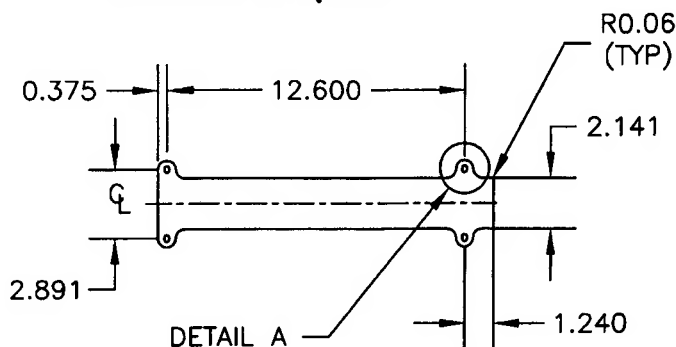
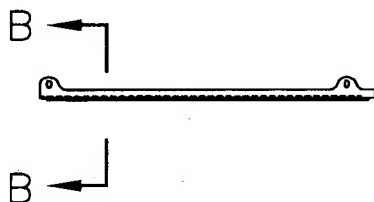
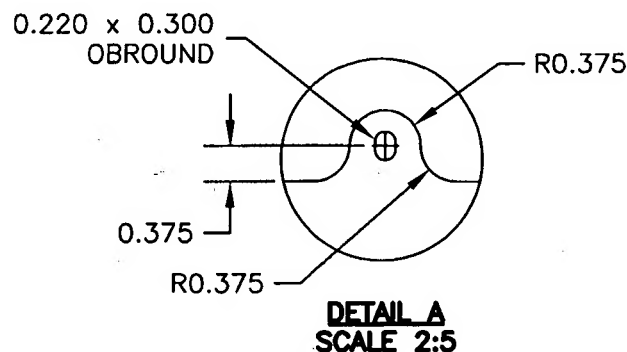
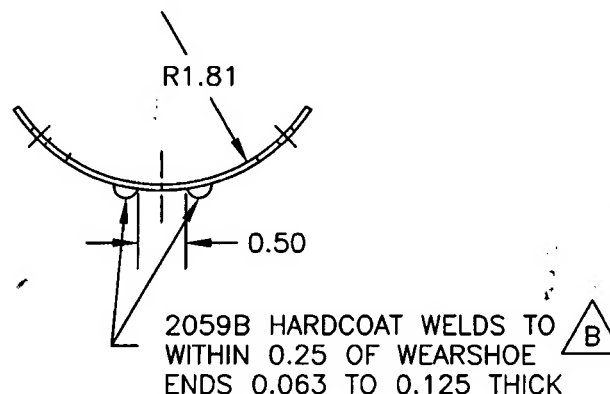
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3512	REV. B SHEET 1 OF 1
DATE 06.10.27		TITLE WEARPLATE	SCALE 1:8
A	06.04.21	NEW ISSUE	
B	06.10.27	CHANGE MATERIAL TO STAINLESS STEEL	

**RELEASED**06.12.12 *[Signature]***D3512-1 FLAT PATTERN****D3512-1 BENDING DETAIL****D3512-1 WEARPLATE**

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK) (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS IN INCHES
- 5) WELD PER DART QSI 004
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31199

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31199
<b>Description:</b> wear plate		<b>Part Number:</b> D35121
<b>Inspection Dwg:</b> 03512 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.375	+/-0.010	0.377	✓	Vern	
B	2.891	+/-0.010	2.888	✓	Vern	
C	2.341	+/-0.010	2.147	✓	Vern	
D	1.240	+/-0.010	1.240	✓	Vern	
E	0.220	+/-0.010	0.224	✓	Vern	
F	0.300	+/-0.010	0.306	✓	Vern	
G	12.600	+/-0.010	12.600	✓	M-T	
H	0.063	+/-0.010	0.060	✓	Vern	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

<b>Measured by:</b> SAD	<b>Audited by:</b> J.L	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/17	<b>Date:</b> 07/03/17	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	